



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2576-1**Job Sheet 190704****Part No:** D2576-1**Job Qty:** 100 pcs**Part Name:** Step (Casting Detail)**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 2/13/19**Job Tracking No:****Due Date:** 3/13/19**Created By:** Chantal Lavoie**Type:** Stock**Description:**

Note: DWG REV G IPP Rev: A New Issue 05-11-29 JLM IPP rev B rev F dwg 07.07.06 EC IPP Rev:C As per Rev G
07-09-05 JLM Verified By:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing DAS FEB 13 2019 13 9-89	100 pcs P10042595	3/13/19	3/13/19	0.00	0.00	Purchasing - 1		DP APR 08 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	100 pcs	3/13/19	3/13/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		

**Container No:** S170577**Part:** D2576-1**Job No:** 190704**Serial No/Batch:** S170577**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/08/19

Plex 2/13/19 1:14 PM dart.lavoie.chanta

				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
120 QC 6	100 pcs	3/13/19	0.00 0.00	QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
130 Packaging 3-1 - Stock - B4B	100 pcs	3/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 -	

DAS
APR 08 2019
9-89

DA 19-04-08

				B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
140 QC 21 - SA	100 pcs	3/13/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op **100** - (Purchasing) Issue P/O: _____ Cast per D2576-1 Pattern vendor: Alpine Non- Ferrous Material Release
 Descriptions: Note Required

110 - (Receive & Inspect for Damage & Mat'l Certs) Ensure D2576 mould is returned with the ordered parts Ensure release note is attached

120 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location: _____) MAT060

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2576-1P	Step (Casting Detail)	100 pcs (1 ea)	100-Purchasing	5170576

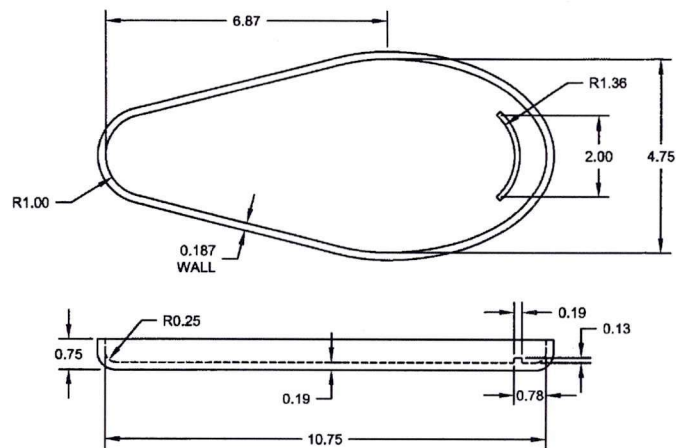
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D2576-1P	100	0	0

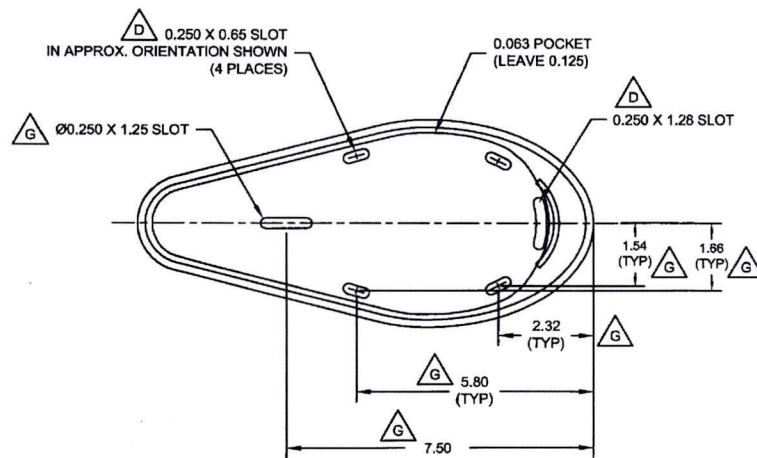
Part Specifications

Specifications could not be found.

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D2576-1 CASTING



D2576-3 MACHINING DETAIL
(MAKE FROM D2576-1)

NOTES:

- 1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
- 6) IDENTIFICATION: NONE

RELEASED

07.08.21

REV.	DESCRIPTION	BY	DATE
G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 6.61	PH	07.04.17
E	CHANGE 0.50 HOLE LOCATION AND ADD NOTE	RF	99.09.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	CP	99.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.08.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D2576
REV. G
SHEET 1 OF 1
TITLE
STEP 1:3

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042595



Supplier: ALN001-VC
Alpine Non-Ferrous Foundry
8657 - 132nd Street
Surrey
BC
V3W 4P1 Canada
Phone: 604 596 8080
Fax: 604 596 8045

PO No: PO042595

PO Date: 2/13/19

Due Date: 3/8/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
FEB 13 2019

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	190704	D2576-1P		Step (Casting Detail) As Per dwg D2576 Rev. G	Firmed - X100		3/8/19	100 pcs	0 pcs	100 pcs	\$17.75/pcs	\$1,775.00

Grand Total: \$1,775.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

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ALPINE NON-FERROUS FOUNDRY

8657-132ND STREET
SURREY, B.C. V3W 4P1
CANADA

WORK ORDER

Order No.: PO042595
Date: 13 Feb, 2019
Page: 1
Ship Date:

Sold To:

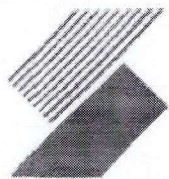
DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

Ship To:

DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
CANADA

Order Date	Purchase Order#	Due Date	Ship Via	Page
13 Feb, 2019	PO042595			1
Item No.	Description	Ordered	Backorder quantity	Shipped quantity
DART D2576	D2576 STEP CSTG GS - GST @ 5% GST PST Exempt: #6122-5207	100	100	100
ALPINE NON-FERROUS FOUNDRY GST: #87550 0001				

Comment: Castings&Patterns are property of Alpine until paid in full



SYMTAX INDUSTRIES ENTERPRISES CORP.

Certificate of Analysis



Lot no.: 107091302

Name: 535.2 Ingot

Date: 2018/09/19

	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn
	%	%	%	%	%	%	%	%
1	0.033	0.079	0.0006	0.230	7.14	0.0033	0.0049	<0.00060
2	0.027	0.079	0.0005	0.200	6.63	0.0028	0.0046	<0.00060
3	0.025	0.080	0.0006	0.204	6.90	0.0033	0.0046	<0.00060
4	0.028	0.078	0.0005	0.219	6.90	0.0027	0.0041	<0.00060
5	0.025	0.080	0.0003	0.186	6.83	0.0034	0.0049	<0.00060

	Ti	Ca	Na	Pb	Sb	Sn	Sr	Al
	%	%	%	%	%	%	%	%
1	0.136	<0.00010	0.0024	0.0025	<0.00040	<0.00050	<0.00010	92.4
2	0.121	<0.00010	0.0019	0.0020	<0.00040	<0.00050	<0.00010	92.9
3	0.143	<0.00010	0.0018	0.0024	<0.00040	<0.00050	<0.00010	92.6
4	0.139	<0.00010	0.0029	0.0022	<0.00040	<0.00050	<0.00010	92.6
5	0.136	<0.00010	0.0017	0.0021	<0.00040	<0.00050	<0.00010	92.7